

# Work Order ID 81391

\*81391\*

Page 1

March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: *MLJ* Date: *12/03/14*

Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2750	F
D3492	C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

*S. Zuehlke*

*JR MLJ 12-4-3*

*B 81391*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81391****\*81391\***

Page 2

March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

**B** 12/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:45:48 AM

Item ID: D350-636-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: *M120/64 BE 12/03/19*

12-Grind welds flush as per Dwg D2750 *→ CF 12-3-20*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*CP 12-03-20*

*1x*

*DP 12-3-20*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

*Handwritten: 12-3-20*

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo


0.00

Quality Control

*Handwritten: 12-3-21*

*Handwritten: PTC*

# Dart Aerospace Ltd

W/O: 81391		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-3-21	150	Should read QC7		12-3-21				

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 81391

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March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 7120513

exp. date: 12-5-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: 7120164

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

12/03/21

12/03/22  
12-03-23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 81391**

March-14-12 7:45:48 AM

**\*81391\***

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CC &gt; 3B / 12/03/27

8/12/03/27

8/12/03/27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 81391

**\*81391\***

Page 7

March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Pressure Wash per QSI005 4.3	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

*1X/ m- 12/03/28*

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>8h25</i>								
	OVEN TEMPERATURE: <i>320°F</i>								
	FINISH TIME: <i>8h55</i>								

*m120222*

*1 12/03/29*

210	<del>QC7</del> -Inspect Chemical Conversion Coat	0.00							
-----	--	------	--	--	--	--	--	--	--

<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

*1X/ m- 12/01/02*

# Dart Aerospace Ltd

W/O: 81391		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/3/30	#2 210	change to QC3 inspection	12/4/32 mk				12/03/30

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

# Work Order ID 81391

**\*81391\***

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March-14-12 7:45:48 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

**\*220\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

*1X/ M/L 12/04/02*

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: *N/A*

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH:

EXP DATE:

*M 120318*

*12/08*

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch:

*M 110348*

5-Coat all exposed fasteners with "LPS Procyon"

batch: *M 114596*

*1X/ M/L 12/04/02*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:45:48 AM

**\*81391\***

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Item ID: D350-636-011

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

*Scrub*

*2/14/13*

*Scrub*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*81391\***

Page 10

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

*Loc 72 R601*

*12/4/12 P*

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

*12/4/12 JF*

*MUF 12-04-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:52 AM

Page 1

Work Order ID: 81391

\*81391\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verf:EC IPP Rev:P 10.06.22 revise  
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	130.0000	8	8			
<b>*D3492-1*</b> Plug													

Location	Loc Qty	Loc Code
FP002	130	
69531	8	
74444	2	
76235	20	
77037 ✓	100	

\*\*

M/A 12/04/02

D3492-3		Manufactured	No			230	Each	69.0000	8	8			
<b>*D3492-3*</b> Plug													

Location	Loc Qty	Loc Code
FP-A	69	
78600 ✓	69	

\*\*

M/A 12/04/02

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:52 AM

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

209.0000

8

8

\*NAS1611-010\*

O-RING

121166

\*\*

8 M/L 12/04/12

Location

Loc Qty

Loc Code

FP	50	
110915	0	
120770	50	
FP001	159	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
120308	36	
120986	50	

NAS1149D0863J

Purchased

No

250

Each

231.0000

2

2

\*NAS1149D0863.J\*

WASHER

\*\*

~~M/L 12/04/12~~  
2 12/4/13

Location

Loc Qty

Loc Code

ST298	231	
118078	36	
119307	95	
120308	100	

D2744

Manufactured

No

110

Each

60.0000

1

1

\*D2744\*

Cap

\*\*

DE 12/13/19

Location

Loc Qty

Loc Code

LG002	60	
62715	1	
70881	10	
71861	7	
78900	42	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-14-12 7:45:53 AM

Work Order ID: 81391

\*81391\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

26.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

(1)

12/03/19

Location

Loc Qty

Loc Code

LG

26

66875

7

73253

1

75021

1

75022

1

75023

1

81330

15

D2743

Manufactured No

160 Each

248.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

BE12/03/22

Location

Loc Qty

Loc Code

LG001

248

67766

4

68251

3

73403

64

74445

1

78603

76

79517

100

D2739

Manufactured No

160 Each

8.0000

1

1

\*D2739\*

350 I Beam

\*\*

Location

Loc Qty

Loc Code

LG

8

72155

1

80083

7

(1) 12/03/22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:53 AM

Work Order ID: 81391

**\*81391\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 38.0000 4 4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

*BE 12/03/22*

Location Loc Qty Loc Code

LG001 38

78800 38

4

D3490-1 Manufactured No

160 Each 49.0000 4 4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

*BE 12/03/22*

Location Loc Qty Loc Code

LG001 49

62450 2

74875 4

77042 3

78793 40

4

ALS4-1032-225 Purchased No

220 Each 1,134.000 38 38

**\*AI S4-1032-225\***

Insert

\*\*

*m-12/04/02*

Location Loc Qty Loc Code

ST281 1021

108696 146

110768 62

118386 55

118966 68

120671 690

38

ST282 113

120410 100

120451 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:53 AM

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

26.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP001

12

80434

12

FP002

14

78935 ✓

14

AN8C35A

Purchased No

230

Each

65.0000

1

1

\*AN8C35A\*

BOLT

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

64

115960

1

117834

10

118286 ✓

53

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured No

230

Each

18.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP001

18

77029 ✓

6

78901

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March-14-12 7:45:53 AM

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230 Each

17.0000 1 1

\*D3488-041\*

Blade Fitting Assembly, LH

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

17

61689

1

75056 ✓

7

77021

9

D3794-3

Manufactured No

230 Each

31.0000 1 1

\*D3794-3\*

Gasket

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

31

74530

2

78895 ✓

5

80436

24

AN6C44A

Purchased No

230 Each

107.0000 4 4

\*AN6C44A\*

BOLT

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

105

120095 ✓

12

120143

25

120465

27

120641

21

121013

20

4

\*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-14-12 7:45:53 AM

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

85.0000

1

1

\*MS21083C8\*

NUT

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436 ✓

9

119638

2

ST304

70

120142

20

120731

25

121011

25

D3536-25

Manufactured

No

230

Each

16.0000

1

1

\*D3536-25\*

Gasket

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

16

78902 ✓

16

D3631-1

Manufactured

No

230

Each

223.0000

8

8

\*D3631-1\*

Washer

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

ST072

223

68062

2

75548 ✓

221

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

March-14-12 7:45:53 AM

Work Order ID: 81391

\*81391\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each

17.0000 1 1

\*D3791-1\*

Wearplate

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP002

17

62239

2

75041 ✓

3

78897

12

AN960C10L NAS1149C0332 R Purchased No

230 Each

0.0000 38 38

\*AN960C10I \*

washer

m118354

\*\*

38 m-l 12/04/02 \*

D2745 Manufactured No

230 Each

136.0000 8 8

\*D2745\*

Bushing

\*\*

m-l 12/04/02

Location

Loc Qty

Loc Code

FP

100

79518

100

FP001

36

69529

1

76142

1

78597 ✓

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:54 AM

Page 9

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

998.0000

34

34

\*AN3C5A\*

Bolt

\*\*

m-12/04/02

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

991

116419

28

117343

13

117764

7

117872

2

119749

23

120423 ✓

918

34

D3537-1

Manufactured

No

230

Each

151.0000

3

3

\*D3537-1\*

Wearpad

\*\*

m-12/04/02

Location

Loc Qty

Loc Code

FP001

104

79833 ✓

50

79835 ✓

54

FP002

47

69817

5

79834

42

3

NAS1149C0832R

Purchased

No

230

Each

304.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

m-12/04/02

Location

Loc Qty

Loc Code

ST297

304

114915

304

1

X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:54 AM

Page 10

Work Order ID: 81391

\*81391\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

623.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

M-L 12/04/02

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

622

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423 ✓

133

120693

400

4

NAS1611-013

Purchased

No

230

Each

168.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

M-L 12/04/02

Location

Loc Qty

Loc Code

FP001

168

116582

5

117291

2

117887

53

119623

36

120360

22

120910 ✓

50

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-14-12 7:45:54 AM

Page 11

Work Order ID: 81391

\*81391\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

19.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

m.p 12/04/02

Location

Loc Qty

Loc Code

FP001

14

62233

1

80331

13

FP002

5

77617 ✓

5

D3794-1

Manufactured No

230

Each

24.0000

1

1

\*D3794-1\*

Gasket

\*\*

m.p 12/04/02

Location

Loc Qty

Loc Code

FP002

24

75042 ✓

12

80435

12

MS21043-6

Purchased No

230

Each

809.0000

4

4

\*MS21043-6\*

NUT

\*\*

m.p 12/04/02

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

789

112314 ✓

83

117887

6

118384

200

120308

500

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:45:54 AM

Page 12

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

66.0000

2

2

\*\*

\*D3493-1\*

Washer

Location

Loc Qty

Loc Code

ST050

66

70697

2

77573

24

78835

40

MS21083C8

Purchased No

250

Each

85.0000

2

2

\*\*

\*MS21083C8\*

NUT

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

AN8C21A

Purchased No

250

Each

51.0000

2

2

\*\*

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

51

118758

5

120094

42

120872

4

March-14-12 7:45:54 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March-14-12 7:45:54 AM

Page 13

Work Order ID: 81391

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*81391\*

\*D350-636-011\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

184.0000

4

4

\*NAS1515H3I \*

WASHER

\*\*

mk 12/04/02

## Location

## Loc Qty

## Loc Code

FG

40

102472

40

ST277

144

118686

3

119438

1

120072

40

120360

100

D2741

Manufactured

No

250

Each

37.0000

1

1

\*D2741\*

Blade, 350 Skidtube

\*\*

sl [SQ]

## Location

## Loc Qty

## Loc Code

ST

-10

ST466

47

71856

1

76984

36

D3532-1

Manufactured

No

250

Each

39.0000

2

2

\*D3532-1\*

Spacer

\*\*

12/34/37 [SQ]

## Location

## Loc Qty

## Loc Code

ST053

39

78839

39

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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WITHOUT NOTICE

WORK ORDER

NO. 81391 MLC  
12/03/14

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# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-B, 8, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9135/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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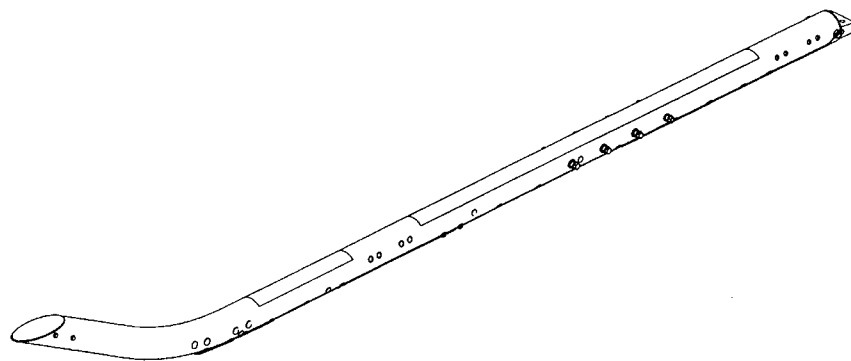
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

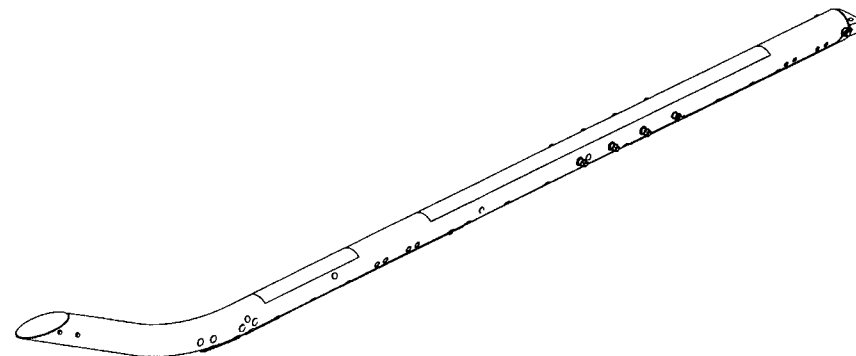
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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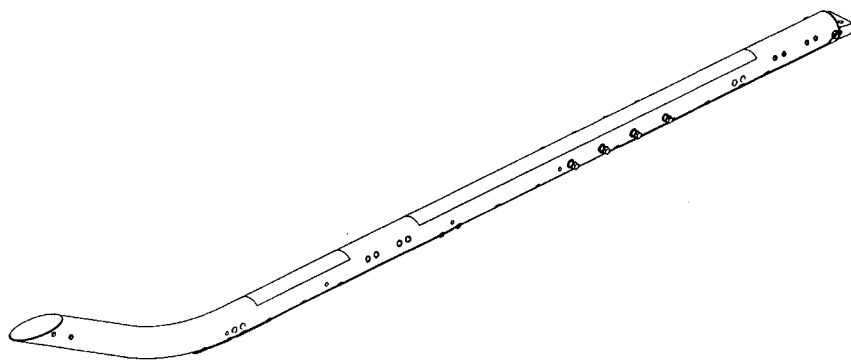
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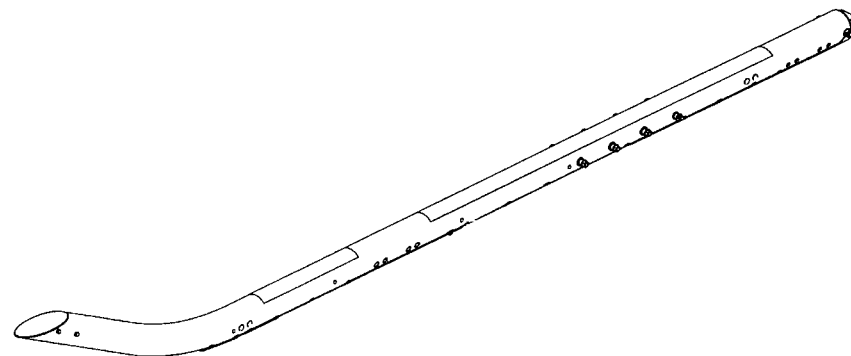
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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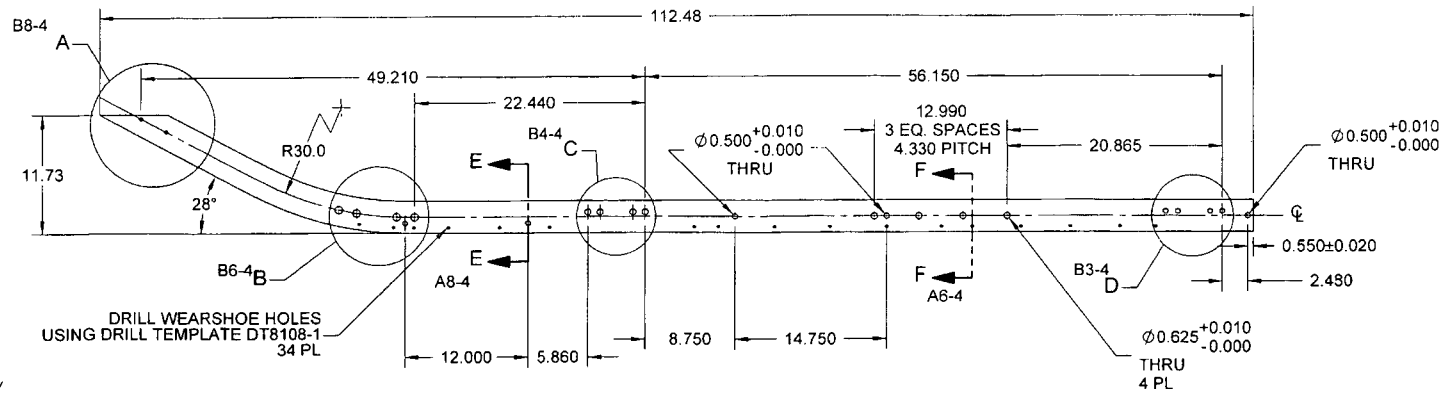
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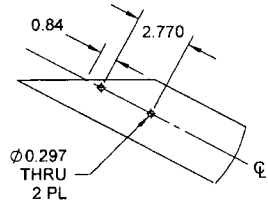
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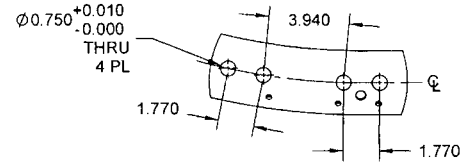


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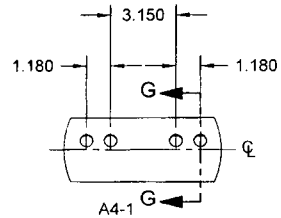
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D7-4



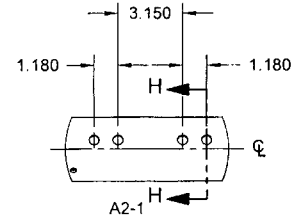
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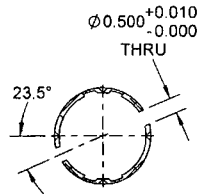
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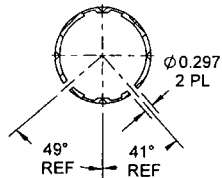
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D3-4



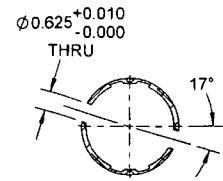
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SCALE 3X, 2 PL

D6-4



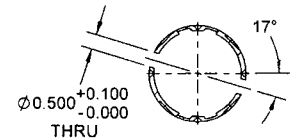
**SECTION F-F**  
SCALE 3X, 17 PL

D4-4



**SECTION G-G**  
SCALE 3X, 4 PL

B4-4



**SECTION H-H**  
SCALE 3X, 4 PL

B2-4

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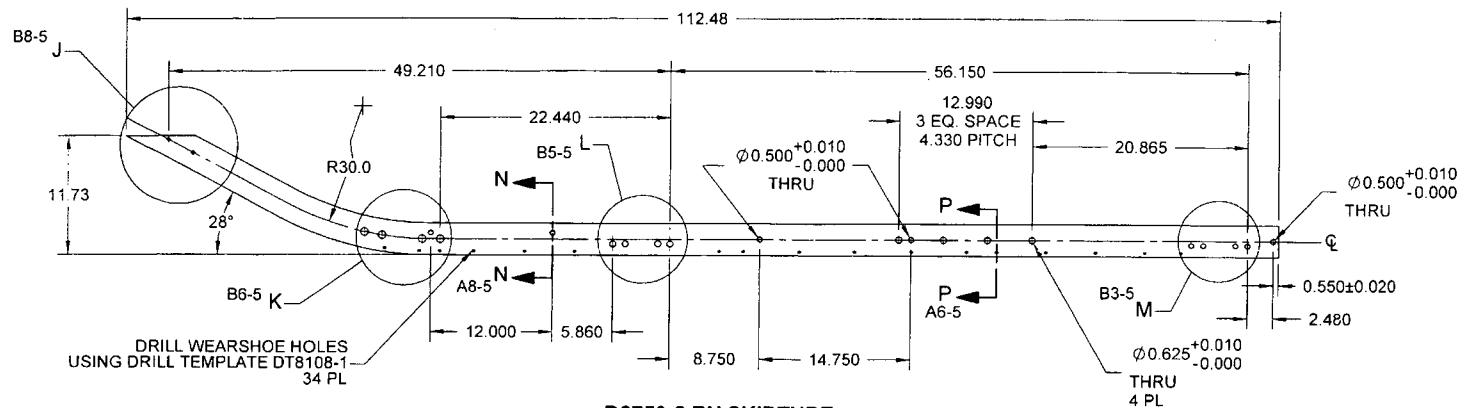
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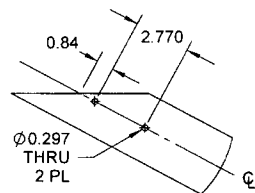
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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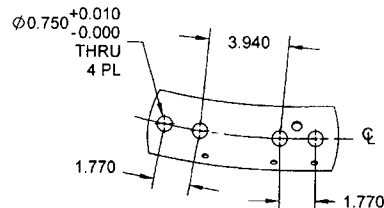
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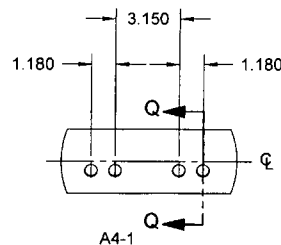
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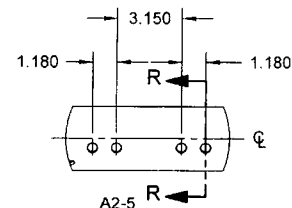
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D8-5



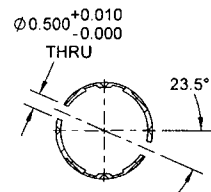
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SCALE 2X  
C7-5



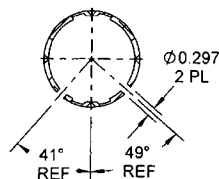
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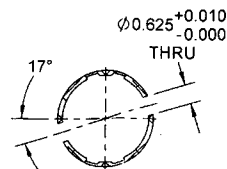
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C3-5



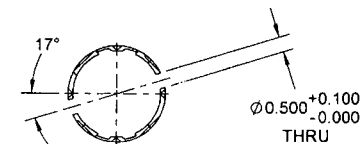
**SECTION N-N**  
SCALE 3X, 2 PL  
C6-5



**SECTION P-P**  
SCALE 3X, 17 PL  
C4-5



**SECTION Q-Q**  
SCALE 3X, 4 PL  
B5-5



**SECTION R-R**  
SCALE 3X, 4 PL  
B3-5

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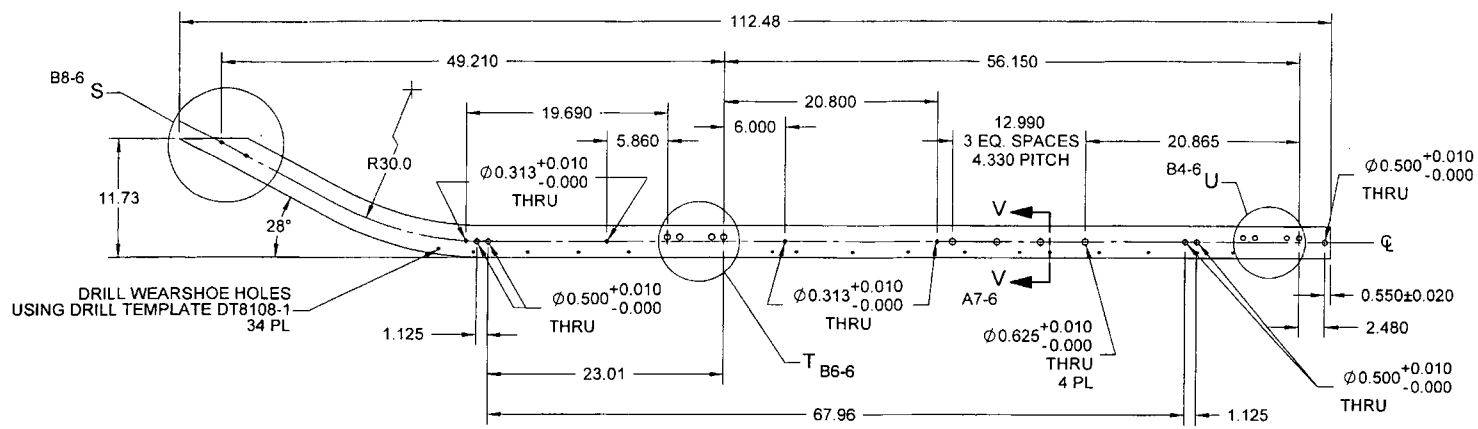
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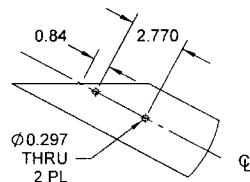
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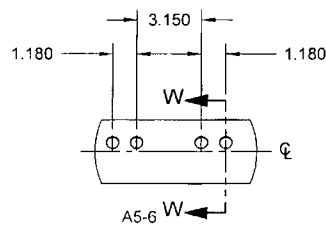
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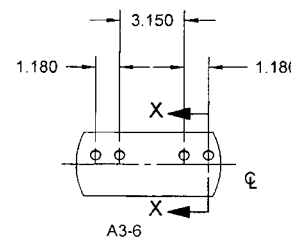
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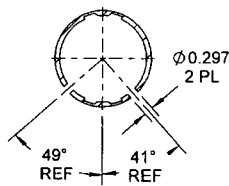
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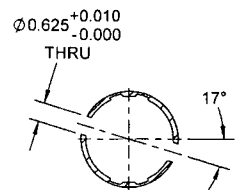
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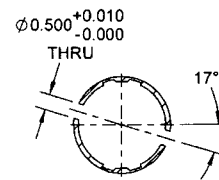
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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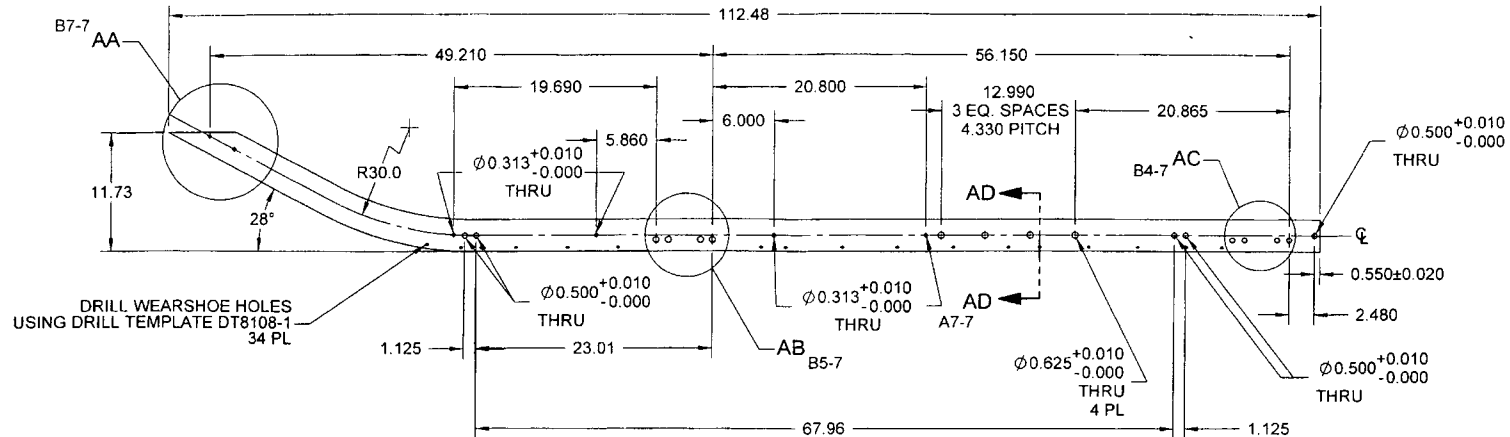
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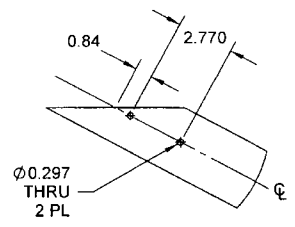
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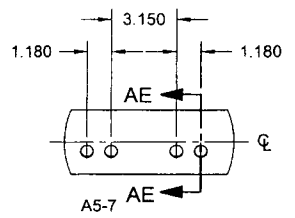
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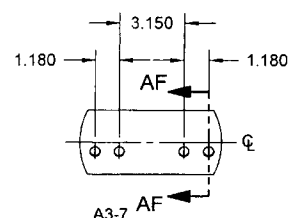
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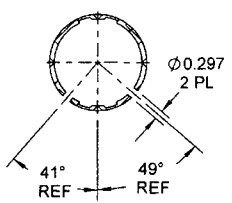
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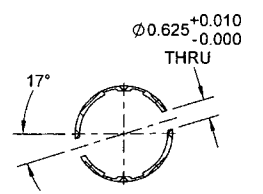
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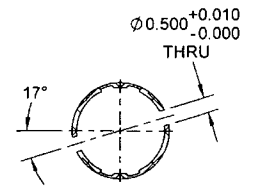
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	5	DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

**SECTION AH-AH**  
SCALE 3X, 4 PL

**SECTION AK-AK**  
SCALE 3X, 4 PL

**SECTION AJ-AJ**  
SCALE 3X, 4 PL

**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**DETAIL AG**  
SCALE 2X

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

**DESIGN**  
DRAWN  
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MFG. APPR.  
APPROVED  
DE APPR.  
DATE

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

**DRAWING NO.**  
D2750

**TITLE**  
350 SKIDTUBE ASSEMBLY

**REV. F**  
SHEET 8 OF 11

**SCALE**  
NTS

**DATE**  
08.07.16

**RELEASED**  
08.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

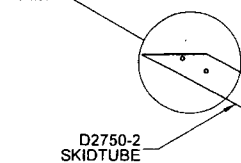
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

A1-9 AM



D2750-2 SKIDTUBE  
AFTER FINISH, ALS4-1032-225 INSERT 34 PL

BLACK ANTI-SKID

AN

AP

AQ

A7-9

13

REFER TO SECTION AP-AP

BOND D2739 WEB INTO D2750-2 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015. NOTE: ENSURE THAT HOLES LINE UP.

2.0 TYP

1.78 TO D2739 WEB

D3488-042 BLADE FITTING

D3794-1 GASKET

D3793-1 WEARSHOE

AN3C5A BOLT  
AN960C10L WASHER 34 PL

D3537-1 WEARPAD

D3791-1 WEARPLATE

D3536-25 GASKET

D3535-25 WEARSHOE

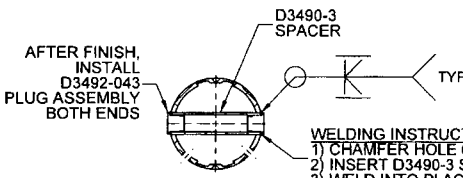
D3537-1 WEARPAD

D3794-3 GASKET

D3793-3 WEARSHOE

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
D3488-042 BLADE FITTING, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)

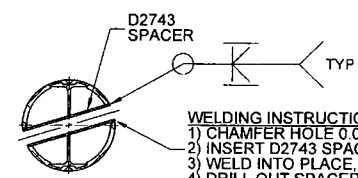
# D2750-042 350 SKIDTUBE ASSEMBLY, RH



AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS

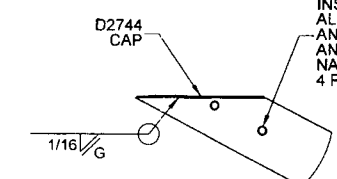
WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-3 SPACER (Ø 0.750 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

SECTION AN-AN  
SCALE 3X, 4 PL



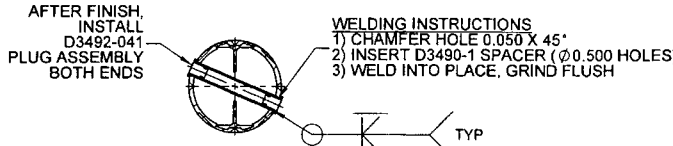
WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484

SECTION AQ-AQ  
SCALE 3X, 4 PL



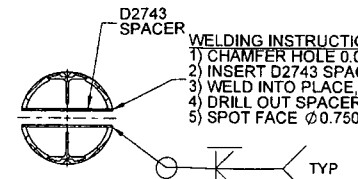
AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

DETAIL AM  
SCALE 2X



WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

SECTION AP-AP  
SCALE 3X, 4 PL



WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484  
5) SPOT FACE Ø 0.750 (BOTH SIDES)

SECTION AR-AR  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

DESIGN	PA	DART AEROSPACE USA, INC.	REV. F
DRAWN	PA	PORT HADLOCK, WA	SHEET 9 OF 11
CHECKED		DRAWING NO. D2750	SCALE NTS
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY	
APPROVED		DATE 08.07.16	
DE APPR.			

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08-09-22/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

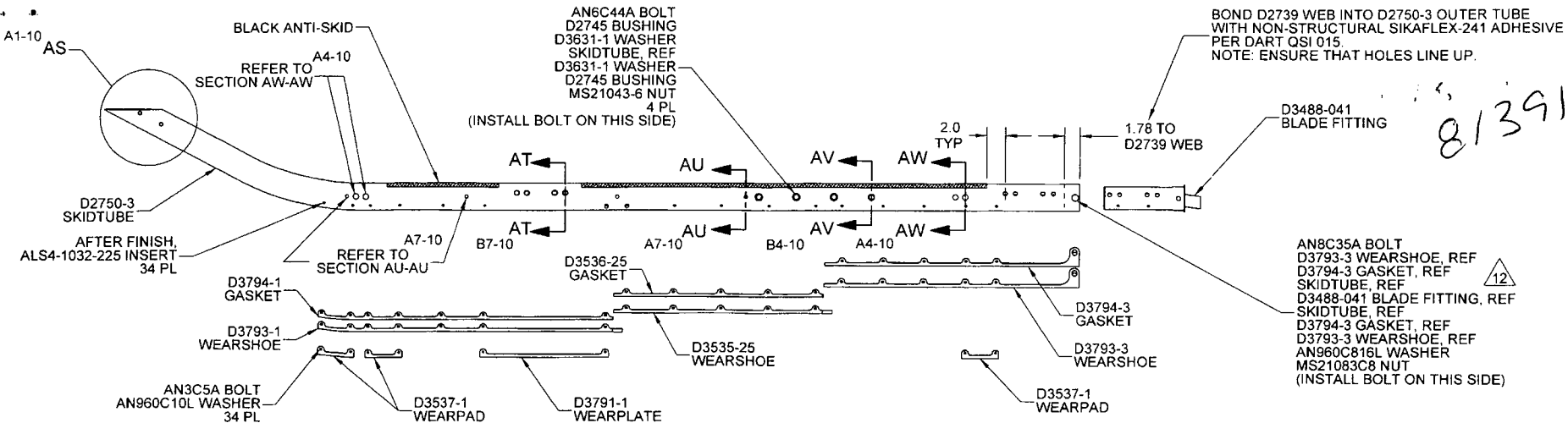
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

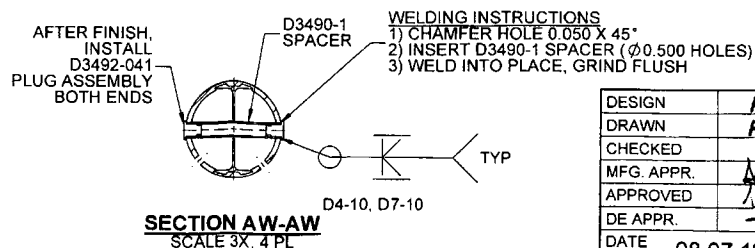
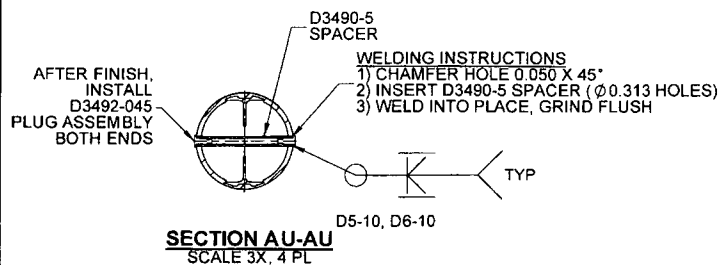
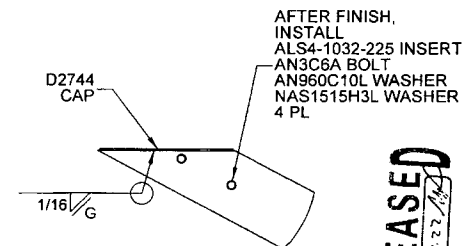
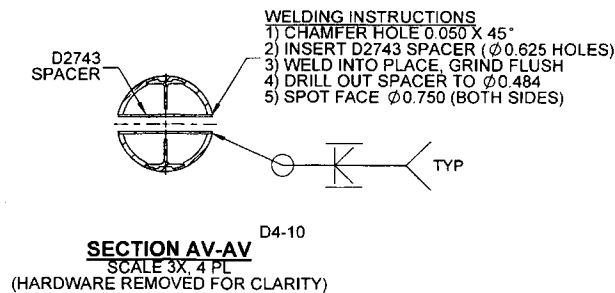
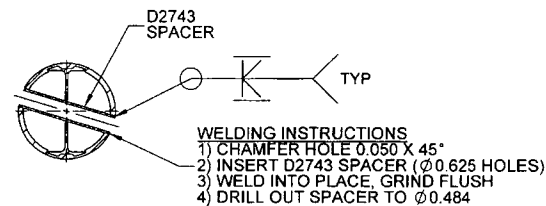
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





### D2750-043 350 SKIDTUBE ASSEMBLY, LH



DESIGN	AS	DART AEROSPACE USA, INC.	REV. F
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	D2750
MFG. APPR.	AS	SHEET 10 OF 11	SCALE
APPROVED	AS	TITLE	350 SKIDTUBE ASSEMBLY
DE APPR.	AS	NTS	
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RELEASED  
28 JUL 22 1998

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 282

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 78413  
Part number: A350-636-011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Newell Date of Test Coupon 12.02.01  
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld